

U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE FORM PTO-1390 (Modified) (REV 10-95)		ATTORNEY'S DOCKET NUMBER 1219
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR 09/1532959
INTERNATIONAL APPLICATION NO. PCT/DE 99/03228	INTERNATIONAL FILING DATE OCTOBER 7, 1999	PRIORITY DATE CLAIMED NOVEMBER 10, 1998
TITLE OF INVENTION METHOD FOR JOINING EXCITATION POLES OF POLE HOUSING, AND ELECTRICAL MACHINE PRODUCED THEREBY		
APPLICANT(S) FOR DO/EO/US Siegfried SCHUSTEK, Peter FRANZ		
Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:		
<ol style="list-style-type: none"> 1. <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371. 2. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371. 3. <input type="checkbox"/> This is an express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1). 4. <input type="checkbox"/> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date. 5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371 (c) (2)) <ul style="list-style-type: none"> a. <input type="checkbox"/> is transmitted herewith (required only if not transmitted by the International Bureau). b. <input checked="" type="checkbox"/> has been transmitted by the International Bureau. c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US). 6. <input checked="" type="checkbox"/> A translation of the International Application into English (35 U.S.C. 371(c)(2)). 7. <input type="checkbox"/> A copy of the International Search Report (PCT/ISA/210). 8. <input type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3)) <ul style="list-style-type: none"> a. <input type="checkbox"/> are transmitted herewith (required only if not transmitted by the International Bureau). b. <input type="checkbox"/> have been transmitted by the International Bureau. c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired. d. <input type="checkbox"/> have not been made and will not be made. 9. <input type="checkbox"/> A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)). 10. <input checked="" type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)). 11. <input type="checkbox"/> A copy of the International Preliminary Examination Report (PCT/IPEA/409). 12. <input type="checkbox"/> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)). 		
Items 13 to 18 below concern document(s) or information included:		
<ol style="list-style-type: none"> 13. <input checked="" type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98. 14. <input type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included. 15. <input checked="" type="checkbox"/> A FIRST preliminary amendment. A SECOND or SUBSEQUENT preliminary amendment. 16. <input type="checkbox"/> A substitute specification. 17. <input type="checkbox"/> A change of power of attorney and/or address letter. 18. <input checked="" type="checkbox"/> Certificate of Mailing by Express Mail 19. <input type="checkbox"/> Other items or information: 		
		

20. The following fees are submitted:

BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)) :

<input type="checkbox"/> Search Report has been prepared by the EPO or JPO	\$930.00
<input type="checkbox"/> International preliminary examination fee paid to USPTO (37 CFR 1.482)	\$720.00
<input type="checkbox"/> No international preliminary examination fee paid to USPTO (37 CFR 1.482) but international search fee paid to USPTO (37 CFR 1.445(a)(2))	\$790.00
<input checked="" type="checkbox"/> Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO	\$1,070.00
<input type="checkbox"/> International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(2)-(4)	\$98.00

CALCULATIONS PTO USE ONLY

\$970.00

Surcharge of \$130.00 for furnishing the oath or declaration later than 20 30 months from the earliest claimed priority date (37 CFR 1.492 (e)). **\$0.00**

CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE	
Total claims	12 - 20 =	0	x \$18.00	\$0.00
Independent claims	1 - 3 =	0	x \$78.00	\$0.00
Multiple Dependent Claims (check if applicable).			<input type="checkbox"/>	\$0.00
				TOTAL OF ABOVE CALCULATIONS = \$970.00

Reduction of 1/2 for filing by small entity, if applicable. Verified Small Entity Statement must also be filed (Note 37 CFR 1.9, 1.27, 1.28) (check if applicable).	<input type="checkbox"/>	\$0.00
		SUBTOTAL = \$970.00

Processing fee of \$130.00 for furnishing the English translation later than months from the earliest claimed priority date (37 CFR 1.492 (f)).	<input type="checkbox"/> 20 <input type="checkbox"/> 30	+ \$0.00
		TOTAL NATIONAL FEE = \$970.00

Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) (check if applicable).	<input type="checkbox"/>	\$0.00
		TOTAL FEES ENCLOSED = \$970.00

	Amount to be: refunded	\$
	charged	\$

- A check in the amount of _____ to cover the above fees is enclosed.
- Please charge my Deposit Account No. 19-4675 in the amount of \$970.00 to cover the above fees. A duplicate copy of this sheet is enclosed.
- The Commissioner is hereby authorized to charge any fees which may be required, or credit any overpayment to Deposit Account No. 19-4675 A duplicate copy of this sheet is enclosed.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.

SEND ALL CORRESPONDENCE TO:

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MICHAEL J. STRIKER

NAME

27233

REGISTRATION NUMBER

JULY 7, 2000

DATE

09/582959

534 Rec'd PCT/PTC 07 JUL 2000

UNITED STATES PATENT AND TRADEMARK OFFICE

Examiner: Group: Attorney Docket # 1219

Applicant(s) : SCHUSTEK, S., ET AL

Serial No. :

Filed : Simultaneously

For : METHOD FOR JOINING EXCITATION POLES OF
POLE HOUSING AND ELECTRICAL MACHINE
PRODUCED THEREBY

SIMULTANEOUS AMENDMENT

July 7, 2000

Honorable Commissioner of Patents and Trademarks
Washington, D.C. 20231

SIRS:

Simultaneously with filing of the above identified application
please amend the same as follows:

In the Claims:

Claim 4 line 1 delete "claims 1-3", substitute with "claim 1".

Claim 5 line 1 delete "claims 1-4", substitute with "claim 1".

Claim 11 line 1 delete "one of the foregoing claims", substitute with "claim 1".

REMARKS:

This Amendment is submitted simultaneously with filing of the above identified application.

With the present Amendment applicant has amended the claims so as to eliminate their multiple dependency.

Consideration and allowance of the present application is most respectfully requested.

Respectfully submitted,


Michael J. Striker
Attorney for Applicant(s)
Reg. No. 27233

09/582959
534 Rec'd PCT/PTC 07 JUL 2000METHOD FOR JOINING EXCITATION POLES OF POLE HOUSING,
AND ELECTRICAL MACHINE PRODUCED THEREBY

Prior Art

5 The invention relates to method for producing a joining connection, in particular between excitation poles and the pole housing of an electrical machine, having the characteristics recited in the preamble to claim 1, as well as to an electrical machine produced thereby.

10 In electrical machines that have an electrical excitation, it is known for the excitation poles that carry the exciter winding to be secured to the inside of a substantially cylindrical pole housing. The securing can be done in a known manner, for instance by means of a welded or adhesive connection or bond. Furthermore, from French Patent Disclosure FR 2488749, a method is known in which excitation poles are secured by stamping dies by means of a nonpositive and positive joining connection, and material of the pole housing is positively displaced into a conical recess of the excitation poles. A disadvantage of this is the high expense for tools and the requisite high precision in aligning the joining tools with the recess. From German Patent DE 2435574, a riveting method is known in which a cylindrical rivet shank is formed by being pressed out of a region of an excitation pole in such a way that the rivet shank is perpendicular to the surface that rests on the inside of the pole housing once the excitation pole has been secured; the rivet shank is inserted through a hole that is cylindrically countersunk on the

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outside of the pole housing, and finally is deformed in such a way that the deformed rivet shank is located entirely inside the countersunk hole. From French Patent FR 2 530 387, a method with a similarly formed rivet shank of an excitation pole is known, in which the rivet shank is inserted from inside through a hole in the pole housing that is countersunk conically from outside; the rivet shank is widened from outside, by positive displacement of material from the axial center of the rivet shank, in such a way that a closing head for positive and nonpositive connection to the pole housing is created in the conical countersunk hole.

From German Patent Disclosure DE-OS 19538483, a method is known in which a joining force is exerted by a joining tool on a joining location located on the outside of a pole housing, and as a result, material from the pole housing is positively displaced into a recess of the excitation poles. This creates a positive and nonpositive connection between the pole housing and the excitation pole.

The rivet connections from German Patent DE 2435574 and French Patent FR 2 530 387 both have the disadvantage that a rivet pin must be formed out of the excitation pole by considerable expenditure of labor; the joining forces are strong; and finally, the machining effort is increased because of the countersinking that follows the perforating of the pole housing. The disadvantages of the method known from DE-OS 19538483 are the high joining forces and the requisite precise alignment of the joining parts.

It is also known to secure the excitation poles to the pole housing using screws with countersunk heads. A

disadvantage of this is the high production cost, which
in addition to the perforating of the parts to be joined
is determined by thread cutting in the excitation pole
and

5 countersinking of the pole housing.

Advantages of the Invention

With the method according to the invention as
defined by the characteristics of the body of claim 1,
it is possible to create a positive and nonpositive
10 connection between the excitation poles and the pole
housing in a simple way compared to the prior art.

Because the pole housing is secured to the excitation
poles by means of separate rivets, a positive and
nonpositive connection is obtained in spot fashion at at
least one joining location. Furthermore, this
connection is achieved by means of simple method steps
and a simple tool.

15 The production cost for the stator comprising the
pole housing and the excitation poles can be reduced
sharply. The pole housing and the excitation poles need
20 to be perforated only at least once each per excitation
pole and then riveted at least once per excitation pole;
the parts to be joined are aligned with one another by
the insertion of the rivets.

25 Further advantages are considered to be that the
absorption of strong forces at the work apparatus and at
the excitation poles, of the kind that have to be
absorbed in the nonpositive and positive joining
connections of the three references cited above, is
30 dispensed with. Since this involves a connection that

can be undone by drilling it open, all the components
except the rivet are re-usable. Compared with the known
securing of the excitation poles with screws, thread
cutting in the pole core and deep countersinking in the
pole housing, the screw itself, and the counterbracing
moment when the screws are tightened are all omitted.
All that is required is an axial alignment and placement
of the excitation pole against the pole housing.

Advantageous refinements of and improvements to
the characteristics recited in the main claim are
obtained by the characteristics recited in the dependent
claims.

Drawings

The invention will be described in further detail
in terms of exemplary embodiments in conjunction with
the associated drawings. Figs. 1a and 1b show a
schematic sectional view through a joining connection by
means of a blind rivet between an excitation pole and a
pole housing, before and after the joining; Figs. 2a-2d
are sectional views of a plurality of variants of an
excitation pole for a joining connection by means of a
blind rivet.

Description of the Exemplary Embodiment

Figs. 1a and 1b in fragmentary sectional form show
a pole housing 10 and an excitation pole 11 of a stator
12 of an electrodynamic machine, which is not shown in
its entirety. As a rule, the electrodynamic machine has
four or six excitation poles 11, which are disposed over
the inside circumference of the cylindrical pole housing

10. The method for producing a joining connection between the pole housing 10 and the excitation poles 11 will be explained in terms of the fragmentary view of an excitation pole 11. A rivet 13 with a conventionally premounted rivet pin 14 is first, as shown in Fig. 1a, inserted from outside with its rivet shank 15 through a previously drilled or punched hole 16 in the pole housing 10. Next, the excitation pole 11, with its also previously produced hole 17 that is radial to the location of the pole housing 10, is thrust over the rivet shank 15 in such a way that the excitation pole 11 rests flat on the inside of the pole housing 10. If the excitation pole 11 is viewed radially from the outside in terms of its installed position in the pole housing 10, the hole 17 of the excitation pole must have the properties of having a minimum diameter in a first hole segment 18, so that the smooth rivet shank 15 can be inserted therethrough. In a second hole segment 19, coaxially following the first, there must be a region with a larger diameter. This second hole segment 19 must be at least long enough that the rivet 13, inserted into the hole 17, can on the one hand rest flush on the outside of the pole housing 10 with its set-head 20, and on the other, the rivet shank 15 can be reshaped to a closing head 22 by a head 21 of the rivet pin 14; after the joining operation has ended, the closing head is located inside the second hole segment 19. The different diameters of the two hole segments 18 and 19 create an annular narrowing 23 of the hole 17 in the excitation pole 11 that rests directly on the inside of the pole housing 10. The two hole segments 18 and 19 are joined to one another via a step 24. The step 24 can for instance, as shown in Fig. 2a, be embodied as a concentric circular-annular shoulder perpendicular to

the axis of the hole, or as a conical jacket face as in Fig. 2d. In the finished joining connection, the narrowing 23 and the pole housing 10 are clamped between the set-head 20 of the rivet 13 and the closing head 22 of the rivet 13, so that a positive and nonpositive connection between the excitation pole 11 and the pole housing 10 is created. Once the excitation pole 11 has been put into flat contact, it is aligned with the cylinder axis, not shown here, of the cylindrical pole housing 10. An alignment of the excitation pole 11 with the pole housing 10 is attainable for instance by securing the excitation pole 11 by means of two axially offset rivets 13, which automatically align the excitation pole 11 in the correct position relative to the pole housing 10. If there is only one rivet per excitation pole 11, then the alignment must be done before the riveting, using an aid such as a gauge. The thus-concluded preparations are then followed by the actual joining operation.

Once the rivet 13 rests with its set-head 20 on the outside of the pole housing 10, a radially outward-acting joining force F is introduced in an upper end region 25 of the rivet pin 14, for instance by means of blind rivet tongs, not shown here. In this operation, the set-head 20 is braced with its side remote from the outside 26 of the pole housing 10 on a face, not shown here, of the riveting tongs.

The introduction of the force F into the rivet pin 14 leads to a pressing action in the boundary face 27 between the head 21 on the lower end of the rivet pin 14 and the lower end of the rivet shank 15. This pressing action consequently leads in this region to a radially

outward-oriented positive displacement of the material comprising the rivet shank 15 through the head 21 of the rivet pin 14, and thus leads to a widening 28 of the rivet shank 15 in the second hole segment 19 of the hole 17 in the excitation pole 11. In the process, the material comprising the shank flows around the head 21. This widening 28 of the rivet shank 15 forms the closing head 22. The closing head attains an outside diameter that is greater than the smallest diameter of the hole 17 of the excitation pole 11.

As the rivet pin 14 is drawn upward, for the head 21 of the rivet pin 14 that widens the rivet shank 15, the resistance to motion increases as the spacing from the narrowing 23 of the hole 17 decreases, and as a result the radial prestressing of the joining connection of the pole housing 10 and the excitation pole 11 increases through the rivet 13. With effort directed to achieving the narrowest possible joining connection, that is, the smallest possible secondary air gap 29 between the pole housing 10 and the excitation pole 11, the force F introduced into the rivet pin 14 is increased. To assure that the cross section of material between the head 21 of the rivet pin 14 and the step 24 will not be weakened by an excessive force F, a rated breaking point 30 leads to the correctly timed interruption of the flow of force; the rivet pin 14 brakes at its rated breaking point 30. The joining operation ends with this breaking of the rivet pin 14. The rivet 13 presses the pole housing 10 and the excitation pole 11 together between its set-head 20 and its closing head 22 created by the widening. Fig. 1b shows the finished joining connection thus made using a blind rivet 13.

In Figs. 2a-2d, various possible designs for the hole 17 of an excitation pole 11 are shown as examples for the production of a joining connection on the pole housing 10 by blind riveting. Fig. 2a shows a hole 17 of the through type 31, which is attained for instance by a stepped perforation with a reduced diameter, for instance by drilling with a step drill. The step 24 between the larger diameter, on the side of the excitation pole 11 remote from the pole housing 10, and the smaller diameter, on the side toward the pole housing 10, is perpendicular to the axis of the hole.

Fig. 2b shows a continuously drilled excitation pole 11, in which the perforating process creates a perforation bead 32, shown in dashed lines, which is subsequently reshaped, by reverse upsetting or pressing down into the narrowing 23 that is required for the joining connection. Fig. 2c shows an excitation pole 11 embodied with a blind bore 33, in which the narrowing 23 is attained as in Fig. 2b. Fig. 2d shows a continuously perforated excitation pole 11, whose hole 17 is attained by metal-cutting machining or reshaping machining or both. The special characteristic here is a conical step 34, whose transitions to the conical jacket face can be rounded. The advantages of such a variant can be better flow conditions and a lesser notch effect at the transition from the rivet shank 15 to the closing head 22. In such a design of the step 34 and with a clearance fit between the rivet shank 15 and the diameter of the upper, first hole segment 18, a centering action of the conical step 34 also occurs, which centers the excitation pole 11 relative to the outside diameter of the rivet shank 15 in the pole housing 10.

It will be clear that the joining method presented here by means of a rivet, preferably a blind rivet 13, is a very simple method of producing a durable positive and nonpositive connection between excitation poles 11 and a pole housing 10 using simple tools. Compared to the methods with a rivet shank formed from the excitation pole, higher clamping forces between the excitation pole and the pole housing are needed before the joining, and in addition stronger joining forces must be brought to bear.

In excitation poles 11 with a continuous hole 31, defective rivet connections can be undone as needed by drilling open the rivet 13 and remaking the connections by the method of the invention. Instead of blind rivets, simple rivets with a solid shank 15 can also be used, since the closing head 22 of such a rivet 13 can be made there by inserting a suitable riveting tool into the through hole 31.

Claims

1. A method for joining excitation poles (11) to a pole housing (10) of electrodynamic machines, in particular starter motors for starting internal combustion engines, in which each joining connection is attained by positive and nonpositive engagement, characterized in that the joining connection is attained by spot shaping of a separate rivet (13), which joins an excitation pole (11) and the pole housing (10), at least one joining location.

2. The method of claim 1, characterized in that a rivet (13) in the form of a blind rivet is employed.

3. The method of claim 1, characterized in that the pole housing (10) is perforated so that a rivet shank (15) can be inserted through it.

4. The method of claims 1-3, characterized in that the blind rivet (13) is introduced into a joining hole (16) from the outside of the pole housing (10).

5. The method of claims 1-4, characterized in that the excitation poles (11) are perforated so that the rivet shank (15) can be inserted through them, and that the widening (28) of the rivet shank (15) that is associated with a riveting operation is effected downstream of a narrowing (23) of a first hole segment (18) in a second hole segment (19) of larger diameter than the first hole segment (18).

6. The method of claim 5, characterized in that the hole (17) in the excitation pole (11) is embodied as

a

through hole (31).

7. The method of claim 5, characterized in that the joining hole in the excitation pole (11) is embodied as a blind bore (33).

8. The method of claim 6, characterized in that the narrowing (23) of the joining hole in the excitation pole (11) is attained by drilling with a step drill.

9. The method of claim 5, characterized in that the narrowing (23) of the hole (31 or 33) in the excitation pole (11) is attained by reverse upsetting of a bead (32) created by perforation.

10. The method of claim 5, characterized in that by means of the conical form of the step (34) attained in the perforation, the excitation pole (11) is centered relative to the pole housing (10) during riveting by the rivet shank (15), which widens in the process.

11. The method of one of the foregoing claims, characterized in that each excitation pole (11) is secured to the inside of the pole housing (10) by means of two axially offset rivets (13).

12. An electrodynamic machine produced by the method of claim 1, in particular for starting internal combustion engines, whose excitation poles (11) are secured to the inside of the pole housing (10), characterized in that the excitation poles (11) are each joined to the pole housing by means of at least one rivet (13).

Abstract

The invention relates to a method for producing a joining connection, in particular between excitation poles (11) and the pole housing (10) of an electrodynamic machine, and to a machine produced by this method, in which by means of a rivet (13), for instance of the blind rivet type, a positive and nonpositive connection is made by inserting this rivet through the perforated pole housing (10) and a perforated excitation pole (11) and widening the rivet shank (15) until the rivet pin (14) breaks off, thus making the connection. It is provided that at least one joining connection per excitation pole (11) is made (Fig. 1b).

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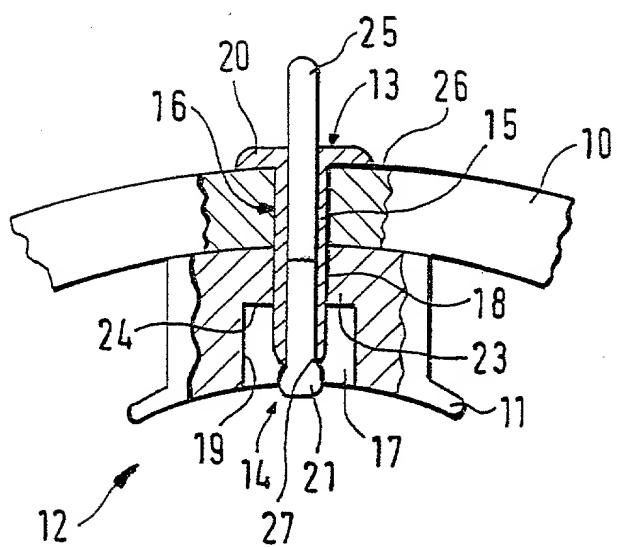


Fig. 1a

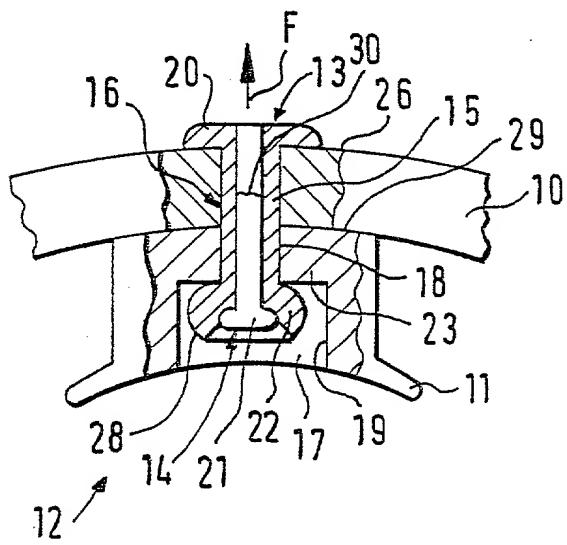


Fig. 1b

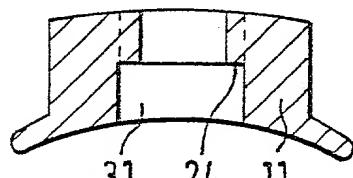


Fig. 2a

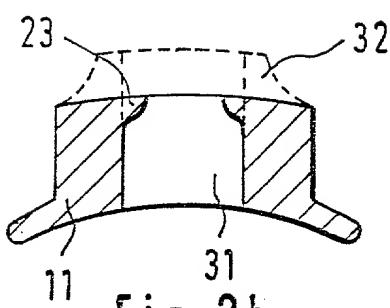


Fig. 2b

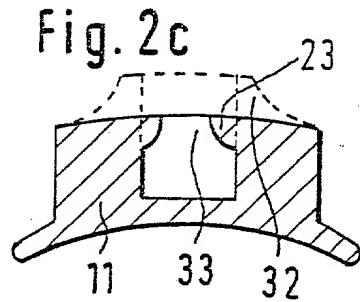


Fig. 2c

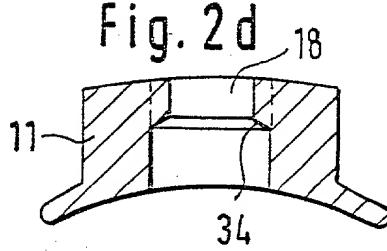


Fig. 2d

DECLARATION AND POWER OF ATTORNEY FOR NATIONAL STAGE OF PCT PATENT APPLICATION

As a below-named inventor, I hereby declare that:

Siegfried SCHUSTEK
Peter FRANZ

My residence, post office address and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled **METHOD FOR JOINING EXCITATION POLES OF POLE HOUSING, AND ELECTRICAL MACHINE PRODUCED THEREBY** the specification of which was filed as PCT International Application number PCT/DE 99/03228 on October 7, 1999

I hereby state that I believe the named inventor or inventors in this Declaration to be the original and first inventor or inventors of the subject matter which is claimed and for which a patent is sought.

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose all information which is material to the patentability of this application in accordance with Title 37, Code of Federal Regulations, Section 1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, Section 119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed.

Prior foreign application(s): Priority claimed:

198 51 639.8 (Number)	GERMANY (Country)	NOVEMBER 10, 1998 (Date filed)	X Yes	_____ No
_____ (Number)	_____ (Country)	_____ (Date filed)	Yes	_____ No

As a named inventor, I hereby appoint the following attorney to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith:

Michael J. Striker, Reg. No. 27233

Direct all telephone calls to Striker, Striker & Stenby at telephone no.: (631) 549 4700 and address and all correspondence to:

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103 East Neck Road
Huntington, New York 11743
U.S.A.

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that wilful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such wilful false statement may jeopardize the validity of the application or any patent issued thereon.

Signature:	Date:	Residence and Full Postal Address: Groeninger Strasse 48 71254 Ditzingen Germany
Full Name of First or Sole Inventor: Siegfried SCHUSTEK	Citizenship: GERMAN	
Signature:	Date:	Residence and Full Postal Address: Schwarze Riehe 27 31199 Diekholzen Germany
Full Name of Second Inventor: Peter FRANZ	Citizenship: GERMAN	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Third Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Fourth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Fifth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Sixth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Seventh Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Eighth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Ninth Inventor:	Citizenship:	

Signature: <i>Siegfried Schustek</i>	Date: <i>30.06.2000</i>	Residence and Full Postal Address: Groeninger Strasse 48 71254 Ditzingen Germany <i>DE</i>
Full Name of First or Sole Inventor: <u>Siegfried SCHUSTEK</u>	Citizenship: GERMAN	
Signature: <i>Peter Franz</i>	Date: <i>5.7.2000</i>	Residence and Full Postal Address: Schwarze Riehe 27 31199 Diekholzen Germany <i>DE</i>
Full Name of Second Inventor: <u>Peter FRANZ</u>	Citizenship: GERMAN	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Third Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Fourth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Fifth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Sixth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Seventh Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Eighth Inventor:	Citizenship:	
Signature:	Date:	Residence and Full Postal Address:
Full Name of Ninth Inventor:	Citizenship:	

DECLARATION AND POWER OF ATTORNEY FOR NATIONAL STAGE OF PCT PATENT APPLICATION

As a below-named inventor, I hereby declare that:

Siegfried SCHUSTEK
Peter FRANZ

My residence, post office address and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled **METHOD FOR JOINING EXCITATION POLES OF POLE HOUSING, AND ELECTRICAL MACHINE PRODUCED THEREBY** the specification of which was filed as PCT International Application number PCT/DE 99/03228 on October 7, 1999

I hereby state that I believe the named inventor or inventors in this Declaration to be the original and first inventor or inventors of the subject matter which is claimed and for which a patent is sought.

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose all information which is material to the patentability of this application in accordance with Title 37, Code of Federal Regulations, Section 1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, Section 119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed.

Prior foreign application(s):

Priority claimed:

198 51 639.8	GERMANY	NOVEMBER 10, 1998	X	
(Number)	(Country)	(Date filed)	Yes	No
_____	_____	_____	_____	_____
(Number)	(Country)	(Date filed)	Yes	No
_____	_____	_____	_____	_____

As a named inventor, I hereby appoint the following attorney to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith:

Michael J. Striker, Reg. No. 27233

Direct all telephone calls to Striker, Striker & Stenby at telephone no.: (631) 549 4700 and address and all correspondence to:

STRIKER, STRIKER & STENBY
103 East Neck Road
Huntington, New York 11743
U.S.A.

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that wilful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such wilful false statement may jeopardize the validity of the application or any patent issued thereon.